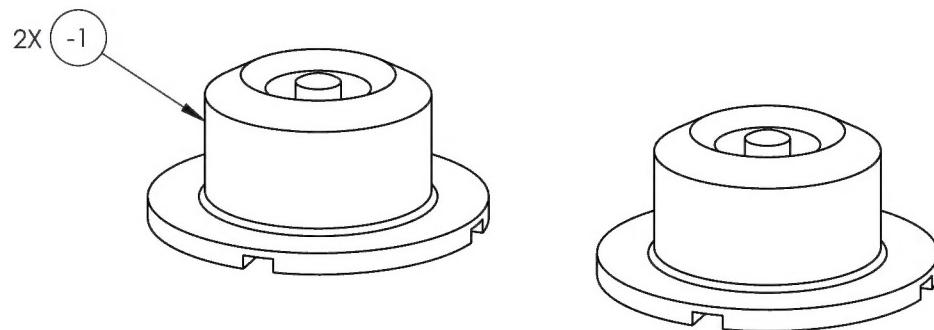


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	12/9/2016	DPD	JAG



NOTES:

- NOTES:**

 1. REF. AIRBUS T/N: 105-31781W6.
 2. USED WITH RBE105-40001W1.
 3. SUPERCEDES 105-31781W4.



TITLE

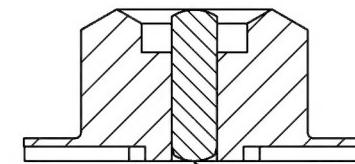
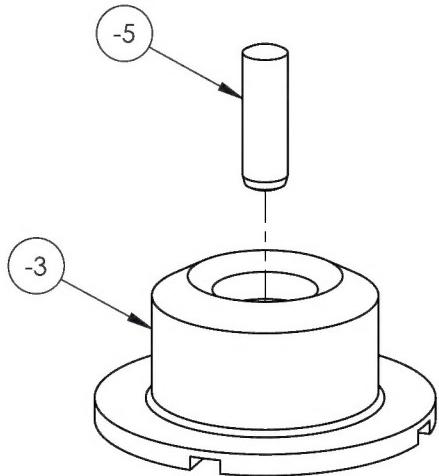
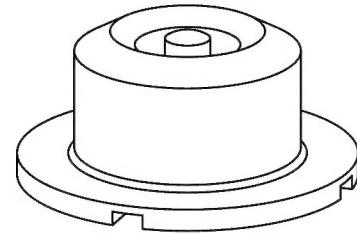
STAKING TOOL

REV
1

								DWG NO.	RBE105-31781W6	REV 1		
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
									HEAT TREAT FINISH	.XXX ± .005	FRACTIONS ± 1/8	
	X		-1	2	STAKING ASSEMBLY			2	SPEC	.XX ± .01	ANGLES ± 5°	
	1		-3		BASE	O1		3	DRAWN BY:	DUERFELDT	X ± .1	
	1	B/O	-5		DOWEL PIN	STEEL	M6 X 20mm (MCMASTER-CARR #91595A452)	2	CHECKED:	CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
	ASSY -1								OPPS APPR:	ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
									QA APPR:	LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
									APPROVED:	GILBERT	USED ON MODEL EC145, EC645	
									SCALE	1:1	DATE 8/22/2016	SHEET 1 OF 3

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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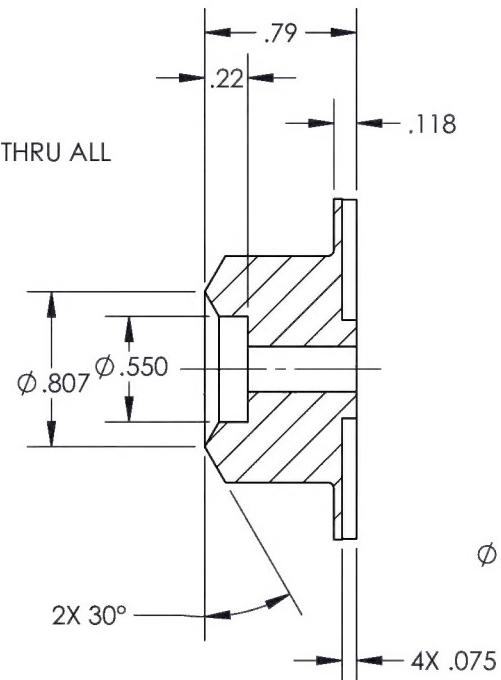
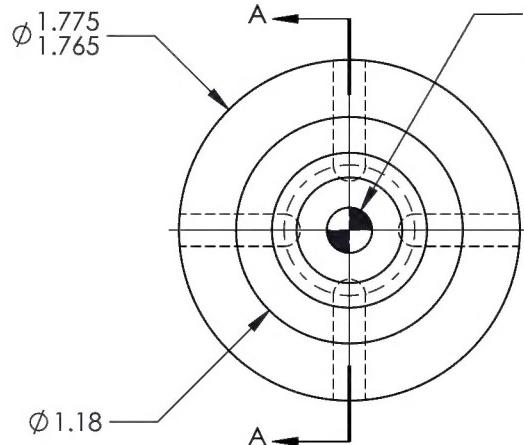
PRESS -5 DOWEL PIN
FLUSH TO BOTTOM
OF -3 BASE

(-1)
STAKING ASSEMBLY

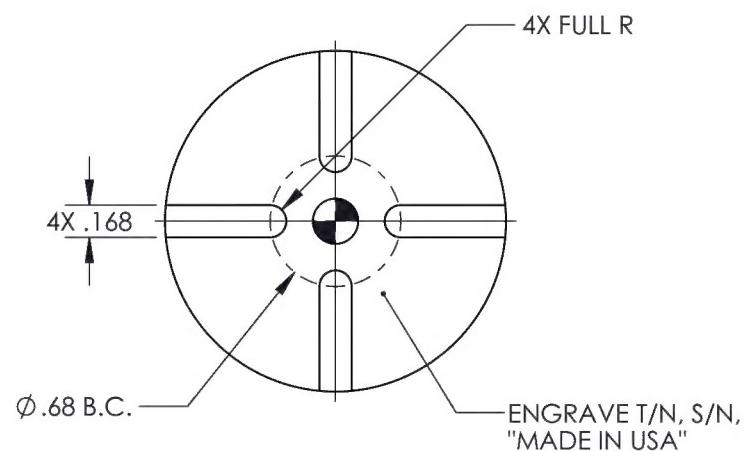
DART AEROSPACE	
TITLE	
DWG NO. RBE105-31781W6-1 REV 1	
MAT'L UNLESS OTHERWISE SPECIFIED HEAT DIMENSIONS ARE IN INCHES TREAT FRACTIONS $\pm \frac{1}{16}$ FINISH ANGLES $\pm 5^\circ$ SPEC ZINC PLATE SURFACES = 125	
ASTM B633 TYPE I SC 2 .XXX $\pm .005$ DRAWN BY: DUERFELDT .XX $\pm .01$ CHECKED: CLOUGH X $\pm .1$ OPPS APPR: ANDERSON 1. BREAK ALL SHARP EDGES QA APPR: LINDSAY 2. DIMENSIONAL LIMITS APPLY APPROVED: GILBERT 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EC145, EC645	
SCALE 1:1	DATE 8/22/2016
SHEET 2 OF 3	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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SECTION A-A



HIDDEN LINES
 OMITTED FOR CLARITY

(3)

BASE

DART AEROSPACE	
TITLE	
STAKING TOOL	
DWG NO.	RBE105-31781W6-3
REV	1
MAT'L O1	
HEAT RC 50-60	
TREAT	
FINISH SEE -1	
SPEC	
DRAWN BY: DUERFELDT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE	1:1
DATE	8/22/2016
SHEET 3 OF 3	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 5°
X ± .1 SURFACES = 125 ✓
1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009
USED ON MODEL
EC145, EC645